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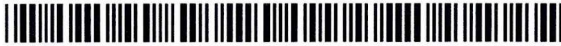
D350-591-311
Job Sheet 194992



Part No: D350-591-311

Job Qty: 1 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No: Airbus

Due Date: 5/14/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	1 pcs	5/14/19		0.00	0.99	Large Fab - 1		MAY 13 2019
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3	DAS	
							Large Fab - 4	24	
							Large Fab - 5	9-89	
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	QC 9	1 pcs	5/14/19		0.00	0.00	QC 9 - 10		a
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
130	QC 5	1 pcs	5/14/19		0.00	0.00	QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



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Container No: S180562



Part: D350-591-311

Job No: 194992

Serial No/Batch: S180562

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issu

140 Handfinish - 1-1 Chemical-B4B	1 pcs	5/14/19	0.00 0.18	QC 5 - 50	FL
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/05/13
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	5/14/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	DAS
					QC 7 - 24	24
					QC 7 - 43	9-89
180 Large Fab - Steps - 2 - B4B	1	5/14/19	0.00 0.99		Large Fab - 1 - B4B	
	pcs				Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	CC
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
190 QC 10	1	5/14/19	0.00 0.00		QC 10 - 10	
	pcs				QC 10 - 18	DAS
					QC 10 - 24	24
					QC 10 - 43	9-89
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
200 QC 5	1	5/14/19	0.00 0.00		QC 5 - 10	
	pcs				QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	DAS
					QC 5 - 22	24
					QC 5 - 24	9-89
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
210 Handfinish - 1-2- Chemical-B4B	1	5/14/19	0.00 0.18		Handfinish - 1 - 1 - B4B	
	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R. 19/05/14
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	

					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
220	Powdercoat - 1 White GI(A)-B4B	1 pcs	5/14/19	0.00 0.29	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-5-14
					Powdercoat - 4 - B4B	
230	Handfinish - 3-1- WingWalk-B4B	1 pcs	5/14/19	0.00 0.18	Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	BEB 19-05-14
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
240	QC 3	1 pcs	5/14/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	MAY 15 2019 DAS 68
					QC 3 - 9	9-89
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
250	Packaging 1-1 - Pick Kit - B4B	1 pcs	5/14/19	0.00 0.00	Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	DAS
					Packaging 1 - 6 - B4B	28
					Packaging 1 - 7 - B4B	9-89
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	

				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	5/14/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
270 Packaging 3-1 - Stock - B4B	1 pcs	5/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
275 DC - 1 - B4B	1	5/14/19	0.00 0.00	DC - 1 - B4B	21
	pcs			DC - 2 - B4B	9-85
280 QC 21 - FG	1	5/14/19	0.00 0.00	QC 21 - FG - 21	DAG
	pcs			QC 21 - FG - 70	21
				QC 21 - FG - 53	9-85

MAY 15 2019

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Part Op 110 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig
 Descriptions: DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush
 120 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
 190 - (QC10- Inspect visual per QSI004- ground welds)
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Chemical Conversion Coat per QSI005 4.1)
 220 - (White Gloss/Ref: 4.3.5.1) per QSI005 4.3- Alum) START TIME: 11:00 OVEN TEMPERATURE: 320°
 FINISH TIME: 11:30
 230 - (Wing Walk as per dwg QSI005 4.4 Batch: 5163430)
 240 - (QC3- Inspect Part Finish)
 250 - (Pick Kit)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-591-311 Location : FG109
 275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-311 CHG001
 280 - (QC21- Final Inspection - Work Order Release)

009822

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 pcs (2 ea)	110-Large Fab - Steps - 1	5125543
D3219-1	Plate	2 pcs (2 ea)	110-Large Fab - Steps - 1	5125734
D3272-1	Step	1 pcs (1 ea)	110-Large Fab - Steps - 1	5180251
D3065-041	Step Leg Assembly	1 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5168662
D3066-1	Spacer	2 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5128757
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5141237-1
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149341
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158578
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167407
D2230-3	Mounting Lug	4 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5176034
D2618	Bushing	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5146466
D2856-400-720	Abrasion Strip 4" X 7.20"	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5179063
D3235-1	Mounting Lug	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5150055
D3278-041	Support Assembly	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5173412
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5157462
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166694
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149145
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5162884
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158585
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167648

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	2	57	0
	D3219-1	2	43	0
	D3272-1	1	4	0
180-Large Fab - Steps - 2 - B4B	D3065-041	1	3	0
	D3066-1	2	31	0
	MS20600-AD4W4	16	2,055	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	2	538	0
	AN4-13A	8	1,237	0
	AN5-36A	2	227	0
	D2230-3	4	378	0
	D2618	2	292	0
	D2856-400-720	2	104	0
	D3235-1	2	202	0
	D3278-041	1	85	0
	MS21042L3	2	2,860	0
	MS21042L4	8	3,120	0
	MS21042L5	2	741	0
	NAS1149D0363J	4	1,953	0
	NAS1149D0463J	16	4,389	0
	NAS1149D0563J	4	3,275	0
Part Specifications				
Specifications could not be found.				

Plex 5/13/19 9:20 AM dart.lacelle.linda

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.